



Katalog/Catalogue	Seite/Page
Stechdrehen und Nutstoßen Grooving and Broaching	2
Supermini und Mini Supermini and Mini	7
Frässysteme Milling Systems	8
Modularle Haltersysteme Modular Holder Systems	10
Bohren und Reiben Drilling and Reaming	12
Formbohren Form Boring	13

Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden. Die passenden Drehmomentschlüssel finden Sie im Kapitel Zubehör.

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws. For torque screw drivers please see chapter additional equipment.

Typ Type	Schraube Screw	M_d Nm	Schlüssel Clamping wrench	Klinge Blade
050	030.0518.T20P	5,0	T20PQ	DT20PK
208	6.16	3,0	SW3DIN911	DSW30K
210	218.3	7,0	SW6DIN911	DSW60K
210...09/...K9	5.32T15P	5,0	T15PQ	DT15PK
211	6.19	3,0	SW3DIN911	DSW30K
213	218.3	7,0	SW6DIN911	DSW60K
213...09	5.32T15P	5,0	T15PQ	DT15PK
213...IK	6.14.912	6,0	SW5DIN911	DSW50K
214	218.3	7,0	SW6DIN911	DSW60K
214...09	5.32T15P	5,0	T15PQ	DT15PK
218	218.3	7,0	SW6DIN911	DSW60K
218...0.03.IK - 0.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
218...2.03.IK - 2.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
218...09/...K9	5.32T15P	5,0	T15PQ	DT15PK
219	218.3	7,0	SW6DIN911	DSW60K
219...09	5.32.3T15P	5,0	T15PQ	DT15PK
221	6.20.70P	5,0	T20PQ	DT20PK
225	218.3	7,0	SW6DIN911	DSW60K
226	218.3	7,0	SW6DIN911	DSW60K
226...09	5.32T15P	4,5	T15PQ	DT15PK
226...0.03.IK - 0.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
226...2.03.IK - 2.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
226.2608...	4.15T15P	5,0	T15PQ	DT15PQ
226.3208...	4.15T15P	5,0	T15PQ	DT15PQ
228	6.20.70P	5,0	T20PQ	DT20PK/DT20PQ
230	5.14	2,5	SW2,5DIN911	DSW25K
232	5.14	2,5	SW2,5DIN911	DSW25K
233	5.14	2,5	SW2,5DIN911	DSW25K
234	5.14	2,5	SW2,5DIN911	DSW25K
235	5.14	2,5	SW2,5DIN911	DSW25K
240	5.14	2,5	SW2,5DIN911	DSW25K
245	51.27.984P	4,0	T15PQ	DT15PK
248	5.14	2,5	SW2,5DIN911	DSW25K
250	5.14	2,5	SW2,5DIN911	DSW25K

Typ Type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
253	5.14	2,5	SW2,5DIN911	DSW25K
254	5.14	2,5	SW2,5DIN911	DSW25K
255	5.14	2,5	SW2,5DIN911	DSW25K
257...05	218.3	6,5	SW6DIN911	DSW60K
257...07/...09	5.32.3T15P	5,0	T15PQ	DT15PK
309	6.25	4,5	SW3DIN911	DSW30K
330	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
333	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
340	6.25	4,5	SW3DIN911	DSW30K
356...3/...5	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
356...45.03	5F.08T20P	5,0	T20PQ	DT20PK/DT20PQ
356...6/...7/...10/...2.13	5.15T20P	6,5	T20PQ	DT20PK/DT20PQ
356...2.13.IK/...2.15.IK	5.15T20P	6,5	T20PQ	DT20PK/DT20PQ
357	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
360	6.25	4,5	SW3DIN911	DSW30K
361	030.0422.T10P	3,0	T10PL	DT10PK
368	4.15T15P	4,0	T15PQ	DT15PK
368...10.01	030.0422.T10	4,0	T10PL	DT10PK
369	6.25	4,5	SW3DIN911	DSW30K
390	6.25	4,5	SW3DIN911	DSW30K
391.1212...	030.0422.T10P	3,0	T10PL	DT10PK
391.1616...	5.32.3T15P	5,0	T15PQ	DT15PK
391.2...	6.25	4,5	SW3DIN911	DSW30K
974	030.3509.T15P	3,0	T15PQ	DT15PK
AH25A.12...02/...03	5.14T20P	2,5/3,0	T20PQ	DT20PK/DT20PQ
AH25A...02/...03	5.13T20P	3,5/3,0	T20PQ	DT20PK/DT20PQ
AK25A...02.IK/03.IK/04.IK	5.13T20P	2,5/3,0/3,5	T20PQ	DT20PK/DT20PQ
B105	6.075T15P	5,0	T15PQ	DT15PK
B105KM	6.075T15P	5,0	T15PQ	DT15PK
BU105	6.075T15P	5,0	T15PQ	DT15PK
B105.A022...	030.0422.T10P	3,0	T10PL	DT10PK
B105MD	DIN913-M5x5	1,0	SW2,5DIN911	DSW25K
B108 / B108KM	2.6.5T8EP	1,2	T8PL	DT8PK
B110	6.075T15P	5,0	T15PQ	DT15PK
B111	3.5.12T10EP	3,0	T10PL	DT10PK
B114	4.12T15EP	5,0	T15PQ	DT15PK
B119	5.11T15P	3,0	T15PL	DT15PK
B209	3.5.12T10EP	2,5	T10PL	DT10PK
B216.0020.1.2...IK	3.5.12T10EP	3,0	T10PL	DT10PK

Typ Type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
B216...IK	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
B223	5.11T15P	3,0	T15PL	DT15PK
B223...K2	4.09T15P	3,0	T15PL	DT15PK
B224.00...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
B224.45... B224.60...	6.14T25P	7,0	T25PQ	DT25PK/DT25PQ
BK224	5.13T20EP	6,5	T20PQ	DT20PK/DT20PQ
BK229	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
BKT	6.075T15P	5,5	T15PQ	DT15PK
E223	5.11T15P	3,0	T15PL	DT15PK
H32T...IK	030.2507.T7P	1,5	T7PL	DT7PK
H34T...10.IK	030.4093.T15P	3,0	T15PQ	DT15PK
H34T...20.IK	030.4010.T15P	5,0	T15PQ	DT15PK
H34T...30.IK	030.5012.T15P	6,0	T15PQ	DT15PK
H34T...40.IK	030.5012.T20P	6,0	T20PQ	DT20PK/DT20PQ
H64T...10.IK	030.4010.T15P	4,0	T15PQ	DT15PK
H64T...20.IK	030.4010.T15P	5,0	T15PQ	DT15PK
H105	6.075T15P	5,0	T15PQ	DT15PK
H100...01/...11/...21 + IK H100...02/...12/...22 + IK H100...71/...72 H100...71R/L/...72R/L	4.15T15P	5,0	T15PQ	DT15PK
H100...03/...13/...23 H100...04/...14/...24 H100...15 H100...1.23.IK	5.17T20P	6,5	T20PQ	DT20PK/DT20PQ
H100...04.IK H100...23.IK/...24.IK H100...73.IK/...74.IK	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
H100...73R/L/...74R/L	DIN912-M5x20	4,0	SW4DIN911	DSW40K
H100...83/...84	030.505P.0718	5,0	T15PQ	DT15PK
H100..83R/L/N/..84R/L/N	030.505P.0660	5,0	T15PQ	DT15PK
H100...93/...93R/L	030.0413.T15P	3,0	T15PQ	DT15PK
H100.2020.3.0.. H100.2525.3.0.. H100.3225.3.0../...38 H100.3225.4.0../...4.1.. H100...08/...10/...12	030.6075.T20P	5,0	T20PQ	DT20PK
H100.3232...	030.0625.T25P	7,0	T25PQ	DT25PK/DT25PQ
H100.52...	5.13T20P	5,0	T20PQ	DT20PK/DT20PQ
H117...10/...12 H117.1407.../.1439... H117.1441.../.1442...	4.09T15P	5,0	T15PQ	DT15PK
H117.1010.10	030.400P0227	5,0	T15PQ	DT15PK

Typ Type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
H117...16/...32/...45 H117.1419.../.1440...	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
H117...20/...26	6.17T20P	7,0	T20PQ	DT20PK/DT20PQ
H117MD	030.400P.0227	5,0	T15PQ	DT15PK
H223	5.11T15P	3,0	T15PL	DT15PK
H223.2608.../.3208...	4.15T15P	5,0	T15PL	DT15PK
H224	6.23T25P	6,0	T25PQ	DT25PK/DT25PQ
H224.1212.81	6.17T25P	5,0	T25PQ	DT25PK/DT25PQ
H224.1608.02/.23/.24 H224.2608.81/.82/.83	4.15T15P	5,0	T15PQ	DT15PK
H224.2608.01/.02 H224.3208.01/.02/.03	4.20T15P	4,3	T15PL	DT15PK
H224.2608.03	4.20T15P	4,3	T15PQ	DT15PK
H224.3208.93	030.0413T15P	3,0	T15PQ	DT15PK
H224...61/...62/...63/...64+IK	4.12.T15EP	5,0	T15PL	DT15PK
H224.1212.20...	4.12.T15EP	5,0	T15PQ	DT15PK
H224...65/...66/...83R	5.13.T20EP	6,5	T20PQ	DT20PK/DT20PQ
H259	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
H262	030.2557.T8P	1,0	T8PL	DT8PK
H264 H264KM	3.5.12T10EP	3,0	T10PL	DT10PK
H274...04/...04.E	030.3509.T15P	3,0	T15PQ	DT15PK
H274...07	030.3513.T15P	3,0	T15PQ	DT15PK
H274KM	030.3509.T15P	3,0	T15PQ	DT15PK
H316	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
HC105	6.075T15P	5,5	T15PQ	DT15PK
HC105MD	DIN911-M4x5	1,0	SW2,0DIN911	SW20K
HC114	4.12T15EP	5,0	T15PQ	DT15PK
HC274KM	030.3509.T15P	3,0	T15PQ	DT15PK
HC316	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
IB25A.20...02.IK/03.IK/04.IK	5.13T20EP	2,5/3,0/3,5	T20PQ	DT20PK/DT20PQ
KT274 KTC274	030.3509.T15P	3,0	T15PQ	DT15PK
L368	4.18T15EP	4,0	T15PQ	DT15PK
L849.0226.L...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LA210	218.3	7,0	SW6.911	DSW60K
LA226	218.3	7,0	SW6.911	DSW60K
LAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
LIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ

Typ Type	Schraube Screw	M_d Nm	Schlüssel Clamping wrench	Klinge Blade
LNK368	5.10T20P	6,0	T20PQ	DT20PK/DT20PQ
LNK760	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
NK100	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK100.0840...	4.20T15P	4,3	T15PL	DT15PK
NK100.3215...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK224.3215...	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
NK224.0840...	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
NK264	4.20T15P	4,3	T15PL	DT15PK
NK274	030.3509.T15P	3,0	T15PQ	DT15PK
NK356	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360.0220...	5.32.3T15P	5,0	T15PQ	DT15PK
NK360.0840.1.01/02/03	030.0422.T10P	3,0	T10PL	DT10PK
NK360.0840.1.04	5.32.3T15P	5,0	T15PQ	DT15PK
NK368	030.400P.0602	4,0	T10PL	DT10PK
R76	030.3509.T15P	5,0	T15PQ	DT15PK
R849.0226.R...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
R849...K2	DIN913-M8x12	7,0	SW5DIN911	DSW50K
RA210	218.3	7,0	SW6.911	DSW60K
RA226	218.3	7,0	SW6.911	DSW60K
RAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
RBA114	4.12.T15EP	5,0	T15PQ	DT15PK/DT15PQ
RIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RHC274	030.3509.T15P	5,0	T15PQ	DT15PK
RIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
SB105	6.075T15P	5,0	T15PQ	DT15PQ
SB110	6.075T15P	5,0	T15PQ	DT15PQ
SH117...08	030.3509.T15P	3,5	T15PQ	DT15PK
SH117...10/...12	4.09T15P	5,0	T15PQ	DT15PK
SH117...16	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
SHM117...08	030.3509.T15P	3,5	T15PQ	DT15PK
VDI	6.075T15P	5,0	T15PQ	DT15PK

Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden.

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws.

Typ type	Schraube Screw	M_d Nm	Schlüssel Wrench	Klinge Blade
001	8.075.1835	5	SW4DIN911	DSW40K
125	3.512T10EP	3	T10PL	DT10PK
145	5.13T20EP	6,5	T20PQ	DT20PK / DT20PQ
962	6.075T15P	5	T15PQ	DT15PK
963	6.075T15P	5	T15PQ	DT15PK
AIH	030.3509.T15P 6.075T15P	2,5 5	T10PL T15PQ	DT10PK DT15PK
B10P	2.6.5T8EP	1,2	T8PL	DT8PK
B11P	3.10T9P	1,8	T9PL	DT9PK
B18P	5.13T20EP	6	T20PQ	DT20PK / DT20PQ
B105	6.075T15P	5	T15PQ	DT15PK
B105.00...A...	030.00M8.1188	4	T25PQ	DT25PK / DT25PQ
B105.00...S...	030.0000.1157	2	T15PL	DT15PK
B105.A022...	030.0422T10P	2	T10PL	DT10PK
B106	1.8.4T6EP	0,9	T6PL	DT6PK
B107	2.2.5T7EP	1,1	T7PL	DT7PK
B108	2.6.5T8EP	1,2	T8PL	DT8PK
B109	6.075T15P	5	T15PQ	DT15PK
B110	6.075T15P	5	T15PQ	DT15PK
B111	3.512T10EP	3	T10PL	DT10PK
B114	4.12T15EP	5	T15PQ	DT15PK
B116	5.13T20EP	6,5	T20PQ	DT20PK / DT20PQ
BA114	4.12.T15P	5	T15PQ	DT15PK
BGT001	DIN912M5x10	5	SW4DIN911	DSW40K
BGT001.C...	DIN912M5x14	5	SW4DIN911	DSW40K
BKT	6.075T15P	5	T15PQ	DT15PK
BKT105...S...	030.0000.1157	2	T15PL	DT15PK
BU105	6.075T15P	5	T15PQ	DT15PK
BU105.00...S...	030.0000.1157	2	T15PL	DT15PK
H105	6.075T15P	5	T15PQ	DT15PK
HC105	6.075T15P	5	T15PQ	DT15PK
HC114	4.12T15EP	5	T15PQ	DT15PK
IR105	6.075T15P	5	T15PQ	DT15PK
KC760	5.12.T20P	6	T15PQ	DT15PK
N	6.075T15P	5	T15PQ	DT15PK
VDI	6.075T15P	5	T15PQ	DT15PK
WFB...105	6.075T15P	5	T15PQ	DT15PK
WFB...110	6.075T15P	5	T15PQ	DT15PK
WFB...14	4.12T15EP	5	T15PQ	DT15PK

Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden.

Following torques are allowed for screws of inserts. We do not recommend using any additional lubricants such as copper paste or similar for the screws.

Typ Type	Schraube Screw	M_d Nm	Schlüssel Clamping wrench	Klinge Blade
380	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
381	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
382...06	5F.06T15P	5,50	T15PQ	DT15PK
382...08	5F.08T20P	5,50	T20PQ	DT20PK
382...10/12/14	5.10T20P	6,50	T20PQ	DT20PK / DT20PQ
383...06	5F.06T15P	5,50	T15PQ	DT15PK
383...08	5F.08T20P	5,50	T20PQ	DT20PK
383...10/12	5.10T20P	6,50	T20PQ	DT20PK / DT20PQ
ABS	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
ADR.01...	C009000	0,75	T6W	DT6K
ADR.02/03...	C009001	1,50	T8L	DT8K
ADR.04/05/06...	C009002	1,50	T8L	DT8K
B105/BKT105	6.075T15P	5,00	T15PQ	DT15PK
B110/BKT110	6.075T15P	5,00	T15PQ	DT15PK
BKT356	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
DAH	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
DAH.M.25.012...	030.2547.T8P	1,30	T8PL	DT8PK
DAH.M.25	030.2553.T8P	1,30	T8PL	DT8PK
DAH.M.37	030.3070.T10P	3,40	T10PL	DT10PK
DAH.M.62	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
DAM31...02B	030.2541.T8P	1,10	T8PL	DT8PK
DAM31...03A/B	030.2547.T8P	1,10	T8PL	DT8PK
DAM31...04A/B	030.2553.T8P	1,10	T8PL	DT8PK
DAM31...05A/B	030.2557.T8P	1,10	T8PL	DT8PK
DAM32...A...	030.3576.T10P	3,50	T10PL	DT10PK
DAM32...02A/B	030.3562.T10P	3,50	T10PL	DT10PK
DAM32.025.D...03A/B	030.3569.T10P	3,50	T10PL	DT10PK
DAM32.032.D...03A/B	030.3576.T10P	3,50	T10PL	DT10PK
DAM32.417...03B	030.3569.T10P	3,50	T10PL	DT10PK
DAM62	030.3070.T10P	3,00	T10PL	DT10PK
DRHD	6.075T15P	5,00	T15PQ	DT15PK
HSK	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
L381.A060...	5F.08T20P	5,50	T20PQ	DT20PK

Typ Type	Schraube Screw	M_d Nm	Schlüssel Clamping wrench	Klinge Blade
L381.D080...	5F.08T20P	5,50	T20PQ	DT20PK
L381.D086...	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
L381.G070...	5.10T20P	6,50	T20PQ	DT20PK / DT20PQ
L381.G080...	5F.08T20P	5,50	T20PQ	DT20PK
L381.G086/090/098	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
L381.N090...	5F.08T20P	5,50	T20PQ	DT20PK
L381.S...	5.15T20P	6,50	T20PQ	DT20PK / DT20PQ
L381.T...	5F.08T20P	5,50	T20PQ	DT20PK
L381.X090...	5.12T20P	6,50	T20PQ	DT20PK / DT20PQ
M101	030.3543.T8P	2,00	T8PL	DT8PK
M101...A22...30/...40	030.0520.0912	6,50	T15PQ	DT15PK
M101...A32...30/...40	030.0620.0913	8,00	T20PQ	DT20PK / DT20PQ
M101...A40...30/...40	030.1030.0911	15,00	SW6,0 DIN911	
M116	5.13T20EP	6,50	T20PQ	DT20PK / DT20PQ
M117K...05	030.265P.0821	1,20	T8PL	DT8PK
M117K...07	030.265P.0819	1,20	T8PL	DT8PK
M117K...09	030.400P.0227	4,30	T15PQ	DT15PK
M117.MD10...	030.400P.0227	4,30	T15PQ	DT15PK
M117U...05	030.265P.0818	1,20	T8PL	DT8PK
M117U...07	2.6.5T8EP	1,20	T8PL	DT8PK
M117P...05	030.265P.0818	1,20	T8PL	DT8PK
M117P...07	2.6.5T8EP	1,20	T8PL	DT8PK
M271	030.2609.T8P	1,20	T8PL	DT8PK
M274	030.3513.T15P	3,00	T15PQ	DT15PK
M275	3.5.10T10P	3,00	T10PL	DT10PK
M275.D	030.357P.0315	3,00	T10PL	DT10PK
M275.T	3.5.10T10P	3,00	T10PL	DT10PK
M279	030.0516.T20P	6,50	T20PQ	DT20PK / DT20PQ
M304	1.8.4T6EP	0,90	T6PL	DT6K
M306	2.6.5T8EP	1,20	T8PL	DT8PK
M308	3.5.12T10EP	3,00	T10PL	DT10PK
M310...03	030.0324.T7P	1,20	T7PL	DT7PK
M310...04	030.3535.T8P	2,00	T8PL	DT8PK
M310...05	030.3543.T8P	2,00	T8PL	DT8PK
M311	4.14T15P	5,00	T15PQ	DT15PK
M311.0016.00.B/E	4.16T15KP	5,00	T15PQ	DT15PK
M313	5.14T20P	6,50	T20PQ	DT20PK / DT20PQ
M313.0016.00.A/B/E	5.13T20KP	6,50	T20PQ	DT20PK / DT20PQ

Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden.

Following torques are allowed for screws of inserts. We recommend using no additional gliding means (such as copper paste) for screws.

Typ Type	Schraube Screw	M_d Nm	Schlüssel Clamping wrench	Klinge Blade
356...3/...5	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
360.00C	030.0410.T15P	5,0	T15PQ	DT15PK
360.TS	030.0410.T15P	6,5	T15PQ	DT15PK
AK25A...02	5.13T20P	2,5	T20PQ	DT20PK/DT20PQ
AK25A...03/04	5.13T20P	3,0	T20PQ	DT20PK/DT20PQ
BK224	5.13T20EP	6,5	T20PQ	DT20PK/DT20PQ
BK229	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
H34T...10.IK	030.4093.T15P	3,0	T15PQ	DT15PK
H34T...20.IK	030.4010.T15P	5,0	T15PQ	DT15PK
H34T...30.IK	030.5012.T15P	6,0	T15PQ	DT15PK
H34T...40.IK	030.5012.T20P	6,0	T20PQ	DT20PK/DT20PQ
H64T...10.IK	030.4010.T15P	4,0	T15PQ	DT15PK
H64T...20.IK	030.4010.T15P	5,0	T15PQ	DT15PK
H100...03/...13/...23 H100...04/...14/...24 H100...15 H100...1.23.IK	5.17T20P	6,5	T20PQ	DT20PK/DT20PQ
H100...04.IK H100...23.IK/...24.IK H100...73.IK/...74.IK	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
H100.2020.3.0.. H100.2525.3.0.. H100.3225.3.0./...38 H100.3225.4.0./...4.1.. H100...08/...10/...12	030.6075.T20P	5,0	T20PQ	DT20PK
K842.SD	001.01.01	0,9	T8PL	DT8PK
K842.SV	001.01.08	2,0	T8PL	DT8PK
K842.SD	001.01.01	0,9	T8PL	DT8PK
K842.SV	001.01.08	2,0	T8PL	DT8PK
LAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
LIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
NK100.0840...	4.20T15P	3,5	T15PQ	DT15PK
NK100.0842...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK100.0845...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ

Typ Type	Schraube Screw	M_d Nm	Schlüssel Clamping wrench	Klinge Blade
NK101.0842...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK101.0845...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK224.0840...	4.20T15P	4,3	T15PQ	DT15PK
NK224.0842...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK224.0845...	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK264.0840...	4.20T15P	4,3	T15PQ	DT15PK
NK274.0840...	030.3509.T15P	3,0	T15PQ	DT15PK
NK356.0840...	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360.0840.1.01/.02/.03	030.0422.T10P	3,0	T10PQ	DT10PK
NK360.0840.1.04	5.32.3T15P	5,0	T15PQ	DT15PK
NK368.0840...08	030.400P.0602	4,0	T10PQ	DT10PK
NK368.0840...11	030.400P.0602	4,0	T10PQ	DT10PK
NK100.3215...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK100.5625...	6.17T25P	7,0	T25PQ	DT25PK/DT25PQ
NK100.7025...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK220.3218...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK224.3215...	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
NK316.0220...	5.12T20P	6,5	T20PQ	DT20PK/DT20PQ
NK356	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360.0220...	5.32.3T15P	5,0	T15PQ	DT15PK
RAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
RIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ

Anzugsreihenfolge der Spannschrauben

Tightening sequence of the clamping screws



Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden.

Following torques are allowed for screws of inserts. We recommend using no additional gliding means (such as copper paste) for screws.

Typ Type	Schraube Screw	M_d Nm	Größe Size	Schlüssel Clamping wrench	Klinge Blade	Drehmoment- schlüssel Torque wrench
B105	6.075T15P	5	T15P	T15PQ	D T15 PK	D 28 VL
B110	6.075T15P	5	T15P	T15PQ	D T15 PK	D 28 VL
B117.DD...3	5.12T20P	6	T20P	T20PQ	DT20PK	D 515 QL
B117.DD...4-6	6.17T20P	7	T20P	T20PQ	DT20PK	D 515 QL
BKT105	6.075T15P	5	T15P	T15PQ	D T15 PK	D 28 VL
BKT110	6.075T15P	5	T15P	T15PQ	D T15 PK	D 28 VL
BKT356	5.12T20P	5,5	T20P	T20PQ	D T15 PK	D 515 QL
MDR016	C009000	0,7	T6	T6L	D T6 K	D 041 VL
MDR016...Z	C009022	4	T15	T15Q	D T15 K	D 28 VL
MDR019	C009000	0,7	T6	T6L	D T6 K	D 041 VL
MDR019...Z	C009023	6	T20	T20Q	D T20 Q	D515QL
MDR024	C009001	1,5	T8	T8L	D T8 K	D 15 VL
MDR024...Z	C009024	16	T30	T30Q	-	-
MDR029	C009001	1,5	T8	T8L	D T8 K	D 15 VL
MDR029-036...Z	C009025	18	T30	T30Q	-	-
MDR036	C009001	1,5	T8	T8L	D T8 K	D 15 VL
MDR044	C009002	1,5	T8	T8L	D T8 K	D 15 VL
MDR052	C009002	1,5	T8	T8L	D T8 K	D 15 VL
MDR061	C009002	1,5	T8	T8L	D T8 K	D 15 VL
MDR08	C009051	0,6	T6	T6L	D T6 K	D 041 VL
MDR081	C009004	3,5	T15	T15Q	D T15 K	D 15 VL
MDR10	C009052	0,9	T7	T7L	D T7 K	D 041 VL
MDR101	C009004	3,5	T15	T15Q	D T15 K	D 15 VL
MDR11...D	C009053...	1,4	T9	T9L	D T9 K	D 15 VL
MDR11...S	C009053B	1,4	T9	T9L	D T9 K	D 15 VL
MDR121	C009004	3,5	T15	T15Q	D T15 K	D 15 VL
MDR13...D	C009054...	2	T10	T10L	D T10 K	D 15 VL
MDR13...S	C009054B	2	T10	T10L	D T10 K	D 15 VL
MDR141	C009004	3,5	T15	T15Q	D T15 K	D 15 VL
MDR150	C002207	8	4	SW4DIN911	D SW 4,0 K	D 28 VL
MDR170	C002207	8	4	SW4DIN911	D SW 4,0 K	D 28 VL
MDR190	C002207	8	4	SW4DIN911	D SW 4,0 K	D 28 VL

Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden.

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws.

Typ Type	Schraube Screw	M_d Nm	Schlüssel Clamping wrench	Klinge Blade
B117.DD.16.3.A.16	5.12T20P	6,0	T20PQ	DT20PK
B117.DD.16.4.A.20	6.17T20P	7,0	T20PQ	DT20PK
B117.DD.20.5.A.26	6.17T20P	7,0	T20PQ	DT20PK
B117.DD.25.6.A.26	6.17T20P	7,0	T20PQ	DT20PK
B117.DD.16.3.E.16	5.12T20P	6,0	T20PQ	DT20PK
B117.DD.16.4.E.20	6.17T20P	7,0	T20PQ	DT20PK
B117.DD.20.5.E.26	6.17T20P	7,0	T20PQ	DT20PK
B117.DD.25.6.E.26	6.17T20P	7,0	T20PQ	DT20PK